

Work Order ID [55962]

February 8, 2010 11:41:35 AM

Page 1

Item ID: D4055-11

Accept

Revision ID:

Item Name: Tank Front and Bottom

Start Date: 2/08/10 Start Qty: 3.00

Required Date: 2/22/10 Req'd Qty: 3.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4055

~~PAT~~

~~PAT~~

3 Rev. A

100

0.00



Purchasing

Memo

0.00

Purchasing

Issue P/O: 11330
Purchase part as per Dwg D4055
Possible Supplier: GFI
Material release note required

PL 10-2-08
3

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

PL 11/3/14 (3)

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

Siobhla to Polen Dwg only

no changes to ~~PAT~~ to Rev A.

not inspect to Release Durs 7 Siobhla

QC APPROVAL

PRELIMINARY ISSUE

Work Order ID 55962

February 8, 2010 11:41:36 AM



Page 2

Item ID: D4055-11

Accept



Setup Start



Revision ID:

Stop



Item Name: Tank Front and Bottom

Start Date: 2/08/10 Start Qty: 3.00



Cust Item ID:

Required Date: 2/22/10 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

N/A

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location:

prelim
shelver

0.00

10.04.19



Packaging

Memo

0.00

Packaging

10.06.28 (2)

Work Order ID 55962

February 8, 2010 11:41:36 AM



Page 3

Item ID: D4055-11

Accept



Setup Start



Revision ID:

Stop



Item Name: Tank Front and Bottom

Start Date: 2/08/10 Start Qty: 3.00



Cust Item ID:

Required Date: 2/22/10 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/06/28 *[Signature]*

[Handwritten signature]

POSITIVE RECALL

EFFECTIVE 10/22/08 AUTH *[Signature]*

RELEASED *[Signature]* DATE 10/06/28 Qty 2

Picklist Print

February 8, 2010 11:41:35 AM

Page 1

Work Order ID: 55962



Parent Item: D4055-11



Parent Item Name: Tank Front and Bottom

Start Date: 2/08/10

Required Date: 2/22/10

Comments: IPP RevA: new issue DD 10.01.08 verified by:JLM

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D4055-11P		Purchased	No			110	Each	0.0000	3.0000			



Tank Front and Bottom



PU 10/3/4 (3)



180 AVENUE LABROSSE
POINT-CLAIRE, QC, CANADA H9R 1A1
TÉL.:(514) 630-4877 - FAX:(514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.



BON DE LIVRAISON / SHIPPING MEMO

DATE DE LIVRAISON / SHIPPING DATE			N° DE BON DE LIVRAISON / SHIPPING MEMO NO.		P
JR - DY	MO. - MO.	AN. - YR			
02	03	10	0433555		17



VENDU À / SOLD TO

EXPÉDIÉ À / SHIP TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

CODE DE CLIENT / CUSTOMER CODE	N° DE CONTRAT / JOB NO.	VOTRE N° DE COMMANDE / YOUR PURCHASE ORDER NO.	EXPÉDIÉ PAR / SHIP VIA		
DART	GFI-0299	0210448	PO11330		
QUANTITÉ / QUANTITY	N° DE PIÈCE / PART NO.	DESCRIPTION			
3	D4055-11P	TANK FRONT AND BOTTOM			
		CERTIFICATE OF CONFORMANCE REQ			
MFG. JOB# J0210448-001 QTY 3					
(1) BOX					

10/03/10

REÇU PAR / RECEIVED BY

DATE

EXPÉDITEUR / SHIPPER

N° DE BON DE LIVRAISON / SHIPPING MEMO NO.



TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION.
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

8
10/03/08

CERTIFICATE NO. 1 OUR JOB NO J0210448 SHIPPING MEMO 0433555

ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
--	3 PCS	PO11330	D4055-11P		TANK FRONT	PA1
MATERIAL		SUPPLIED BY		MAT. REL. NO.		
AL 6061-T6		SAMUEL / ALCOA INC		608951		

	PROCESS	PROCESSOR	RELEASE NOTE #
1	FIRST ARTICLE INSPECTION REPORT ON FILE	GFI	CONFORMS
2	REF. GFI MANUFACTURING JOB NUMBER J0210448-001 (3 PCS)		
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 03 MARCH 2010

G.F.I. Q.C. REP. *Dalton Arnold*





LES METAUX SPECIALISES SAMUEL
21525 CLARK-GRAHAM
BAIE D'URFE, QUEBEC, CANADA
H9X 3T5

(514) 457-3399

FAX (514) 457-9393

No 00159185



PAGE 1 DÉ/OF 1

TRANSPORTEUR/CARRIER NAME
ASTERO TRANSPORT

CAMION/TRUCK

099

NOM DE LA BRANCHE/SALES BRANCH NAME

SAMUEL & FILS & CIE (QUEBEC) L

DATED/EXP. DATE OF SHIPMENT

2/16/10

VENDU À/SOLD TO:

GFI, DIVISION DE THOMAS & BETTS LTEE
180 LABROSSE

EXPÉDIÉ À/SHIP TO: TÂB: PPD

GFI INC.
180 LABROSSE

POINTE-CLAIRE

QC

POINTE-CLAIRE

QC

H9R1A1

(514) 630-4877

H9R1A1

CA

(201009-00001)

N° COMMANDE

N° ITEM

000752-01

DESCRIPTION ET POIDS/DESCRIPTION AND WEIGHT

#Comm du client: 76423
4 PCS AL. SH. 6061 T6
.0630"x48"x144"

Cert/Test: FAX

174 LVR

OOA 250/11

#Pièce AS06348144QM

Description

Art

Pd ca

Qté

#Étiq

Vendeur Org

#Étiq mln

#À soul

4

192.000

174

Étq princ

#Coul

US

764479

4947487 ALR D654824 608951

Total:

4

192.000

174

Poids total:

#Total paquets:

1

174 LVR

Commentaires connaissance:

CERTIFICAT DE CONFORMITÉ

LE MATÉRIEL DÉTAILLÉ CI-DESSUS EST CERTIFIÉ

CONFORME AUX EXIGENCES DE VOTRE COMMANDE ET AUX

SPÉCIFICATIONS DES NORMES DU GRADE. SVP VOUS

RÉFÉREZ AUX CERTIFICATS CI-JOINTS. AUTORISÉ PAR:

Melissa Diamond
MÉLISSA DIAMOND
ADMINISTRATION

DATE 16/02/10



16/02/10

NIR: R-539477-1

REL. PAR	PORT PAYÉ/PREPAID	PORT D'COLLECT	INST. VOITURIER/DRIVER INSTRUCTIONS	VALEUR (\$2,000 max moins d'avis contraire) VALUATION (Max \$2,000 unless otherwise stated) VALUE DECLARÉE DE L'EXPÉDITION DECLARED VALUE OF SHIPMENT
CHARGES			VOITURIER/DRIVER	REÇU PAR/RECEIVED BY
EXPÉDITEUR/DISPATCHER				


ORIGINAL - NON NÉGOCIABLE (CE CONNAISSEMENT DOIT ÊTRE SIGNÉ PAR L'EXPÉDITEUR ET LE VOITURIER)

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

Kenton P. Young
Quality Assurance Manager

PITTSBURGH, PA DAVENPORT WORKS
Ship From: RIVERDALE, IA.

1058276	0	Ship From:		RIVERDALE, IA.
Ship Date	B.L. No.	Invoice No.	Alcoa No.	Item
2009-10-15	4303234	00000	1000143904-6	
P.O. No./Govt Contract No.	Customer	Alcoa Item		Page 1
N22238 Ln#: 6	SAMUEL SON & CO LT		G041110647R02	DCE-43904-6

Item Description
0.063 IN TK (+0.0000 -.0035) X 48.0 IN W (+.125 -
-.125) X 144.0 IN LN (+.15625 -.15625) (N) A/T 6061-
T6 FLAT SHEET FOR DISTRIBUTORS TOLERANCE
GUARANTEED. AMS4027 REV N EXC MRK ASME-SB-
209 REV 07 EXC MRK ASTMB209 REV 07
CMMPO25 REV S CMMPO19 REV D ((MARKED))
KRAFT PAPER INTERLEAVED MAX GROSS
SKID WGT: 4500 LB QUAN TOL +/-30 %
CQR 0222751 REV 02 CUST REQ 09-10-
01 *** W/E 09-10-24 *** 

Num	Package Ticket	Lot	Weight	Quantity	UOM	Pc Id/Serl	Inspector Clock Numbers
1	764477	608951	4119				
2	764478	608951	3408	100	PC	:	27299 47004
3	764479	608951	4149	83	PC	:	27299 47004
			100		PC	:	27299 47004
			11676	283			

Notes for CQR: 0222751.2
PRODUCT PRODUCED TO THE REQUIREMENTS OF AMS4027 REV N ALSO MEET THE REQUIREMENTS OF AMS-QQ-A-250_11 ORIGINAL REVISION DATED 1997-08-01.
CQR: 0222751.2 - Significant

Temp	Dir	UTS	TYS	EL4D
T6	Long Transv.	KSI	KSI	PCT
	Max			
	Min	42.0	35.0	10

Chemical Composition		SI	FE	CU	MN	MG	CR	ZN	TI	Other Each	Other Total	Aluminum
Alloy 6061	Max	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05	0.15	
	Min	0.40		0.15		0.8	0.04					REMAIN

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA

DAVENPORT WORKS

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

Per:

Malcolm Murphy
Director of Manufacturing Davenport Works

Kenton P. Young
Quality Assurance Manager

1058276

Ship Date

0

B.L. No.

Invoice No.

Alcoa No. Item

Page 2

2009-10-15

4303234

00000

1000143904-6

DCE-43904-6

P.O. No./Govt Contract No.

Customer

Alcoa Item

N22238 Ln#: 6

SAMUEL SON & CO LT G041110647R02

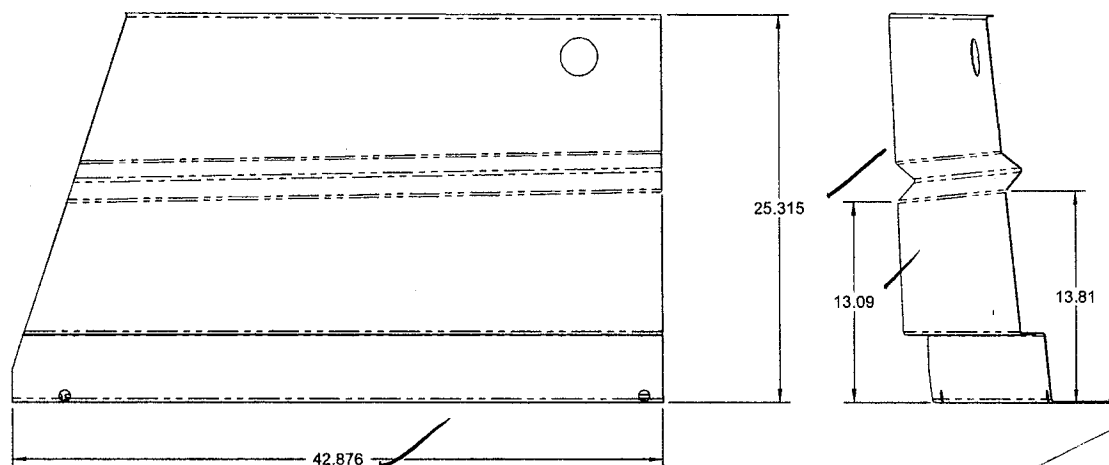
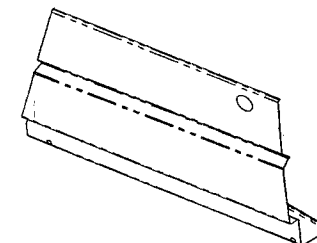
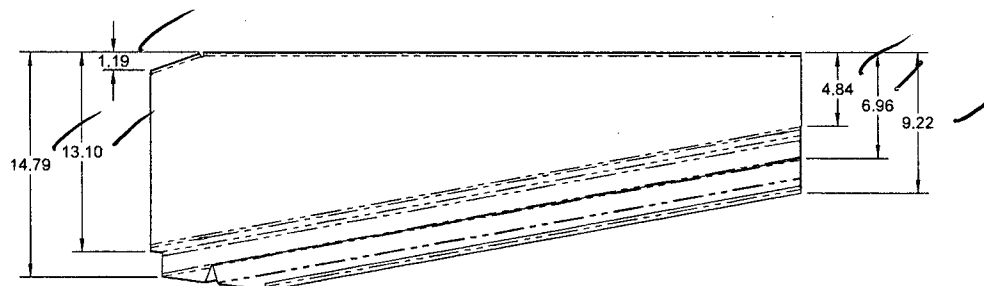
CQR: 0222751.2 -Specification Limits (cont.)
Lot: 608951

- Mechanical, Physical, Metallography, Quantometer Results

Temp	Dir	No->	UTS	TYS	EL4D
T6	Long Transv.	Test	KSI	KSI	PCT
		2	50	44.8	10.9
			49.9	44.8	10.9

Cast Number	Chemical - OES	SI	FE	CU	MN	MG	CR	ZN	TI
H8054013	Actuals	0.66	0.5	0.26	0.06	0.9	0.19	0.05	0.02

This material was melted in the United States or a Qualifying Country [REF DFARS 225.872.1(a)]; it was manufactured in the United States



D4055-9 TANK FRONT AND BOTTOM

See Rev A

NOTES:

- 1) MATERIAL: MADE FROM D4055-11F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.34 lbs

PRELIMINARY ISSUE

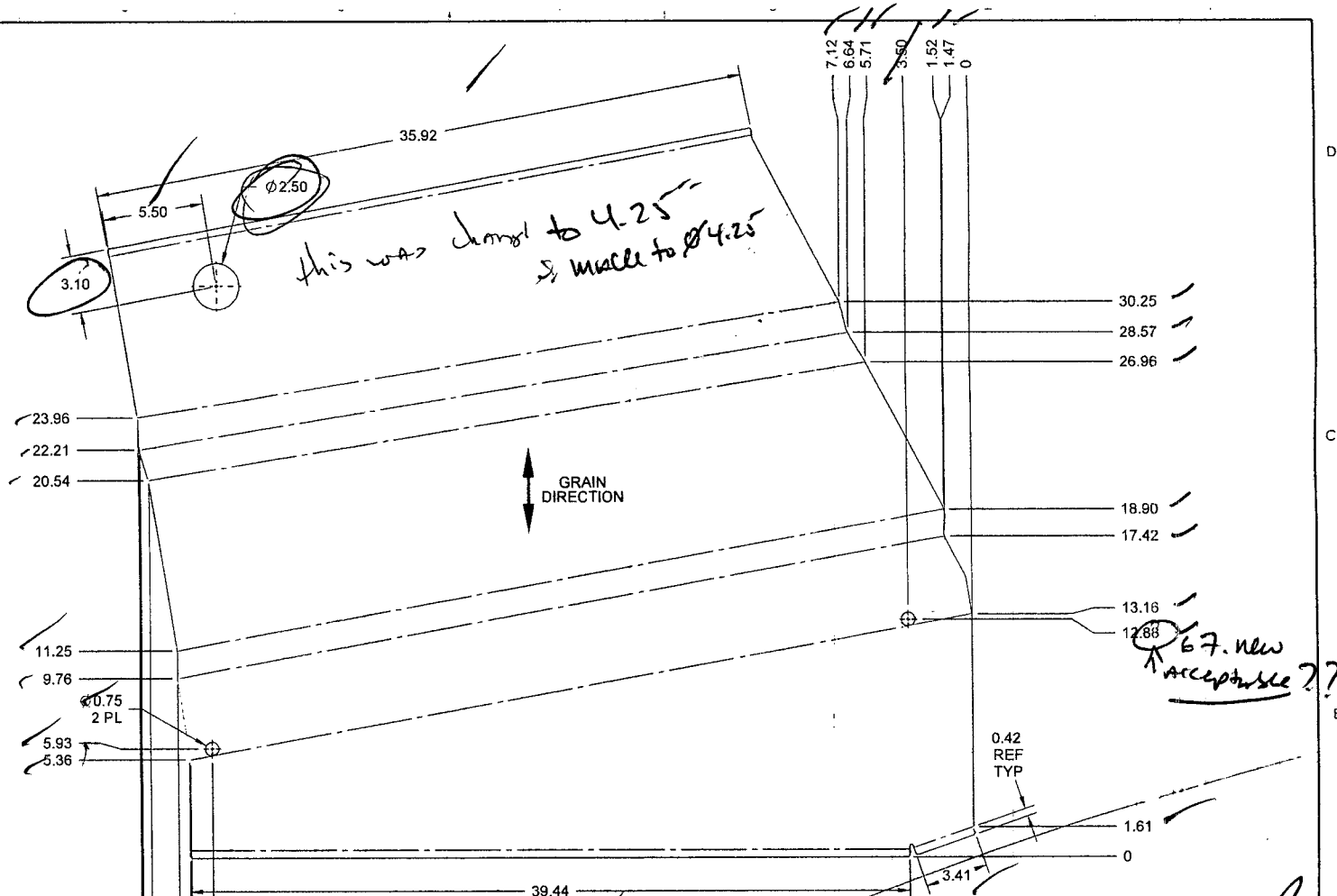
10.01.11

DESIGN
DRAWN
CHECKED
MFG. APPR.
APPROVED
DE APPR.
DATE 10.01.11

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. PA1
D4055
TITLE
TANK
SCALE
NTS

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D4055-11F FLAT PATTERN

PRELIMINARY ISSUE

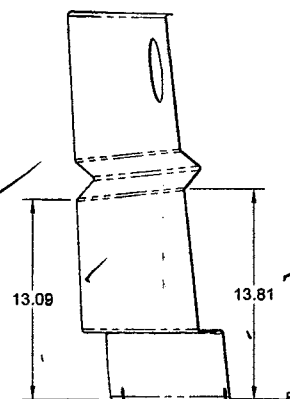
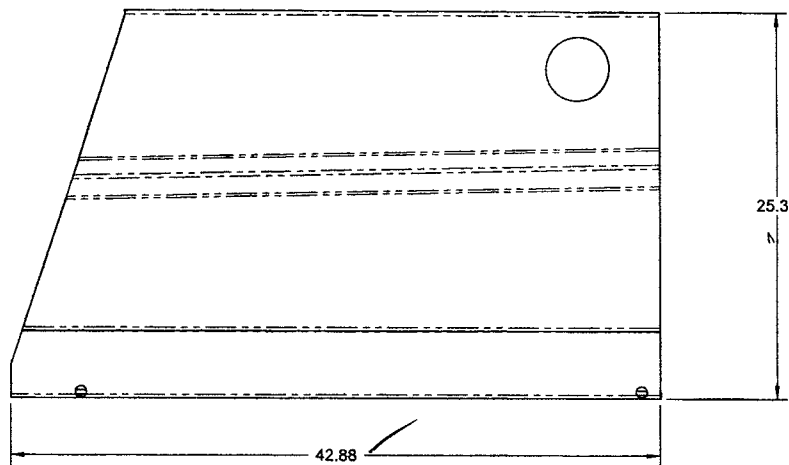
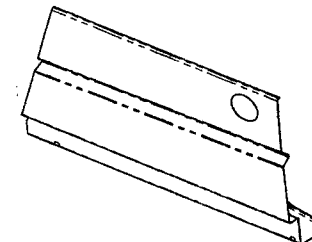
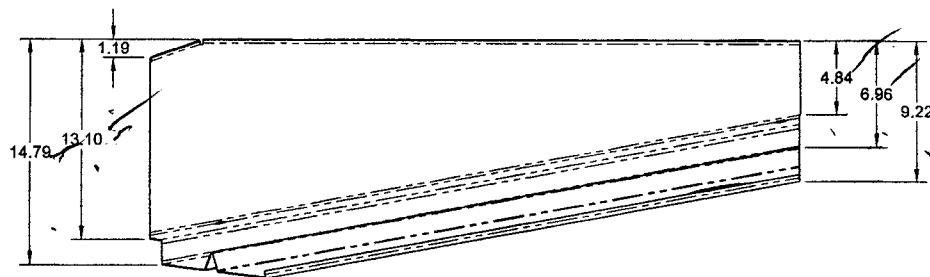
10.01.11

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.34 lbs

DESIGN	DART AEROSPACE LTD	
DRAWN	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DRAWING NO.	REV. PA1
MFG. APPR.	D4055	SHEET 15 OF 15
APPROVED	TITLE	SCALE
DE APPR.	TANK	NTS
DATE	10.01.11	

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D4055-11 TANK FRONT AND BOTTOM

PRELIMINARY ISSUE

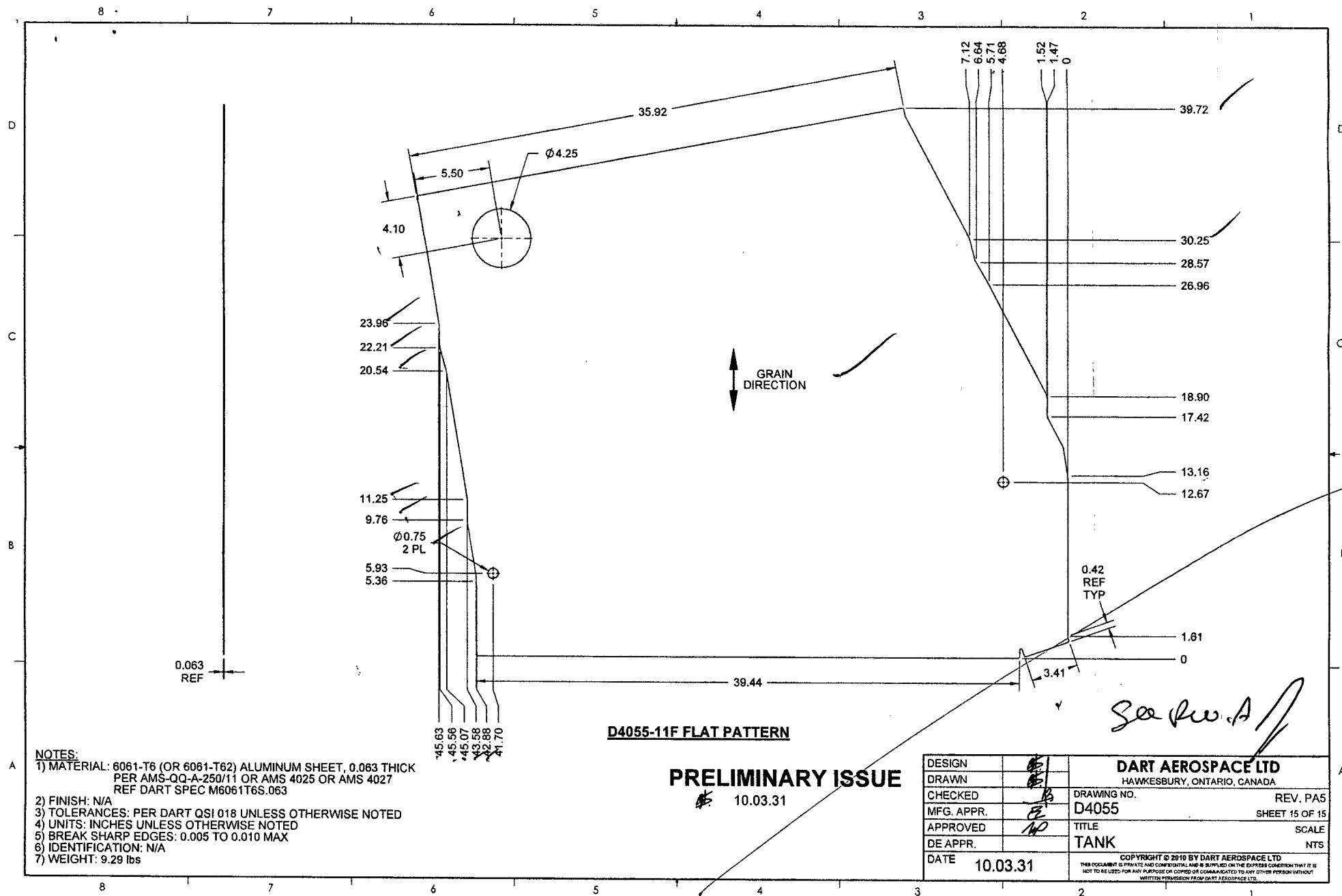
10.03.31

NOTES:

- 1) MATERIAL: MADE FROM D4055-11F
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.29 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PAS
MFG. APPR.		D4055	SHEET 14 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
DATE	10.03.31	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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see kwsj



D4055-11F FLAT PATTERN

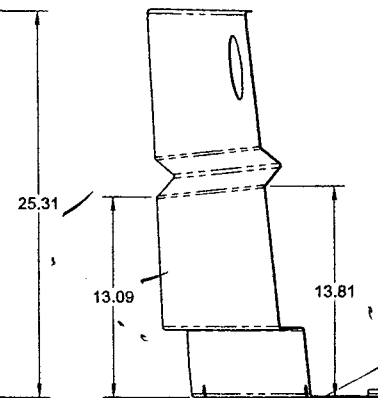
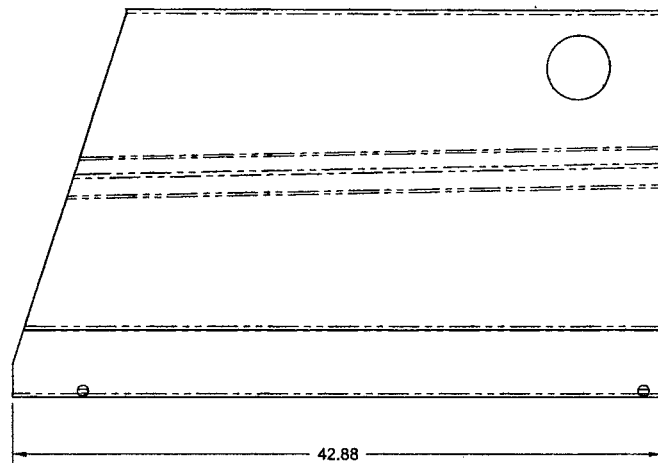
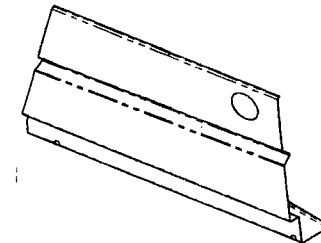
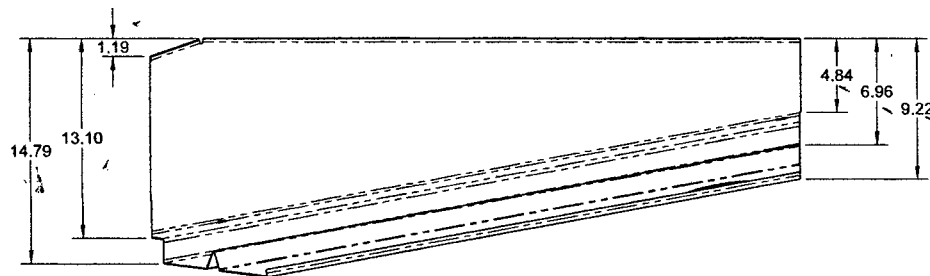
PRELIMINARY ISSUE

10.03.31

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.29 lbs

DESIGN	<i>EE</i>	DART AEROSPACE LTD	
DRAWN	<i>EE</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>EE</i>	DRAWING NO.	REV. PA5
MFG. APPR.	<i>EE</i>	D4055	SHEET 15 OF 15
APPROVED	<i>NO</i>	TITLE	SCALE
DE APPR.		TANK	NTS
DATE	10.03.31	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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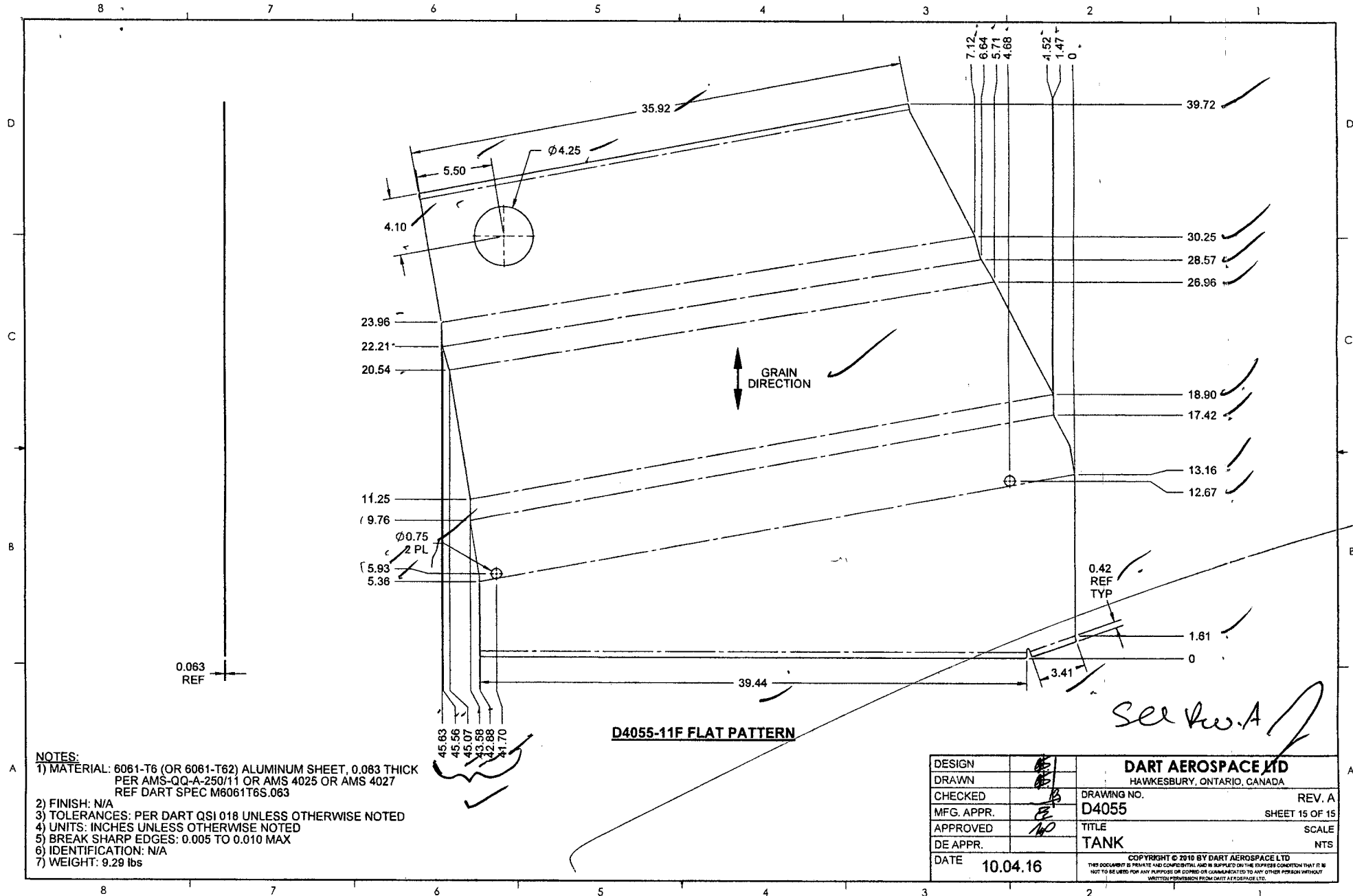
D4055-11 TANK FRONT AND BOTTOM

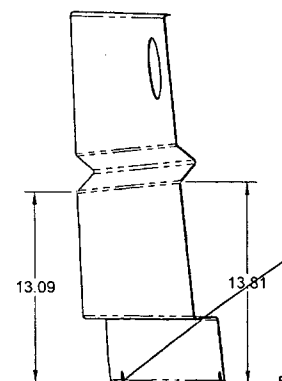
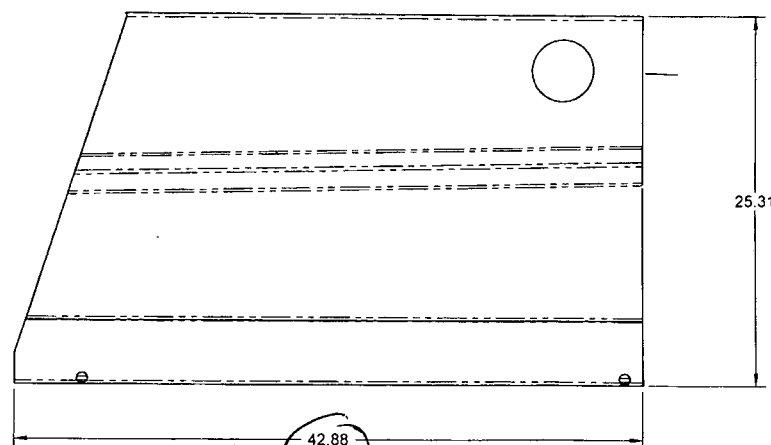
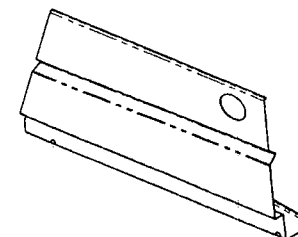
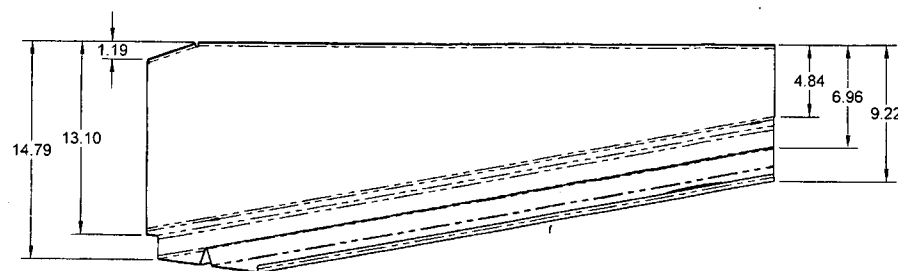
See Rev. A.

NOTES:

- 1) MATERIAL: MADE FROM D4055-11F
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.29 lbs

DESIGN	<i>AS</i>	DART AEROSPACE LTD	
DRAWN	<i>AS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>AS</i>	D4055	SHEET 14 OF 15
APPROVED	<i>AS</i>	TITLE	SCALE
DE APPR.	<i>AS</i>	TANK	NTS
DATE	10.04.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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42.88
43.56

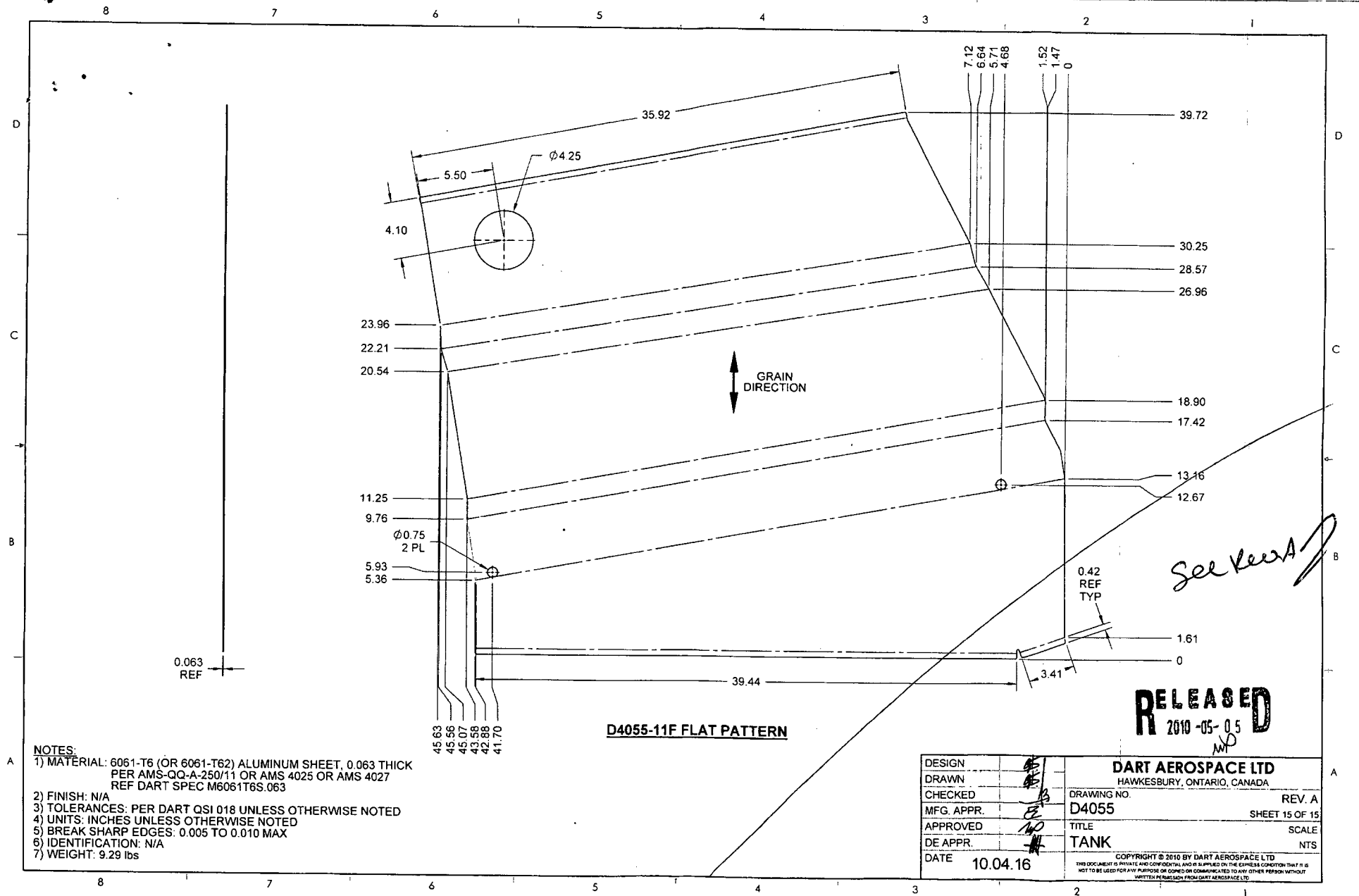
D4055-11 TANK FRONT AND BOTTOM

See Rev. A

RELEASED
2010-05-05
JMP

- NOTES:**
- 1) MATERIAL: MADE FROM D4055-11F
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 9.29 lbs

DESIGN	43	DART AEROSPACE LTD	
DRAWN	43	HAWKESBURY, ONTARIO, CANADA	
CHECKED	43	DRAWING NO.	REV. A
MFG. APPR.	43	D4055	SHEET 14 OF 15
APPROVED	43	TITLE	SCALE
DE APPR.	43	TANK	NTS
DATE	10.04.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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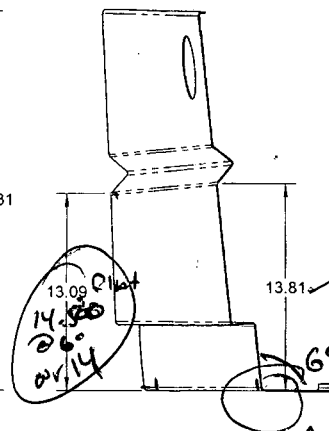
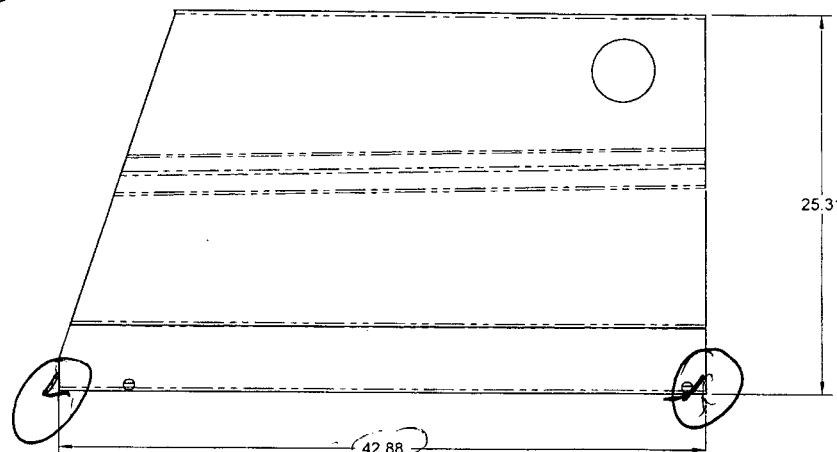
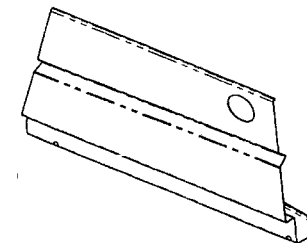
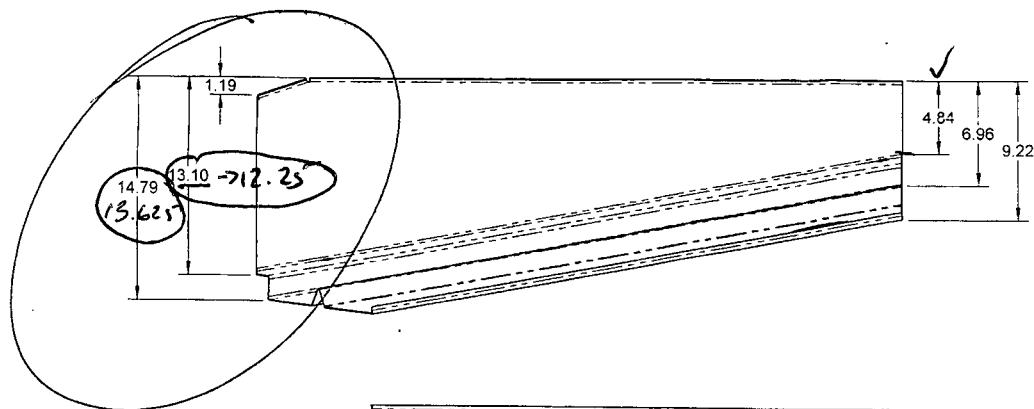


RELEASE
2010-05-05

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4055	REV. A
	SHEET 15 OF 15
TITLE TANK	SCALE NTS

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good!
10.26


Angle?

RELEASED
2010-05-05
JMP

D4055-11 TANK FRONT AND BOTTOM



- NOTES:
- 1) MATERIAL: MADE FROM D4055-11F
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 9.29 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4055	SHEET 14 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
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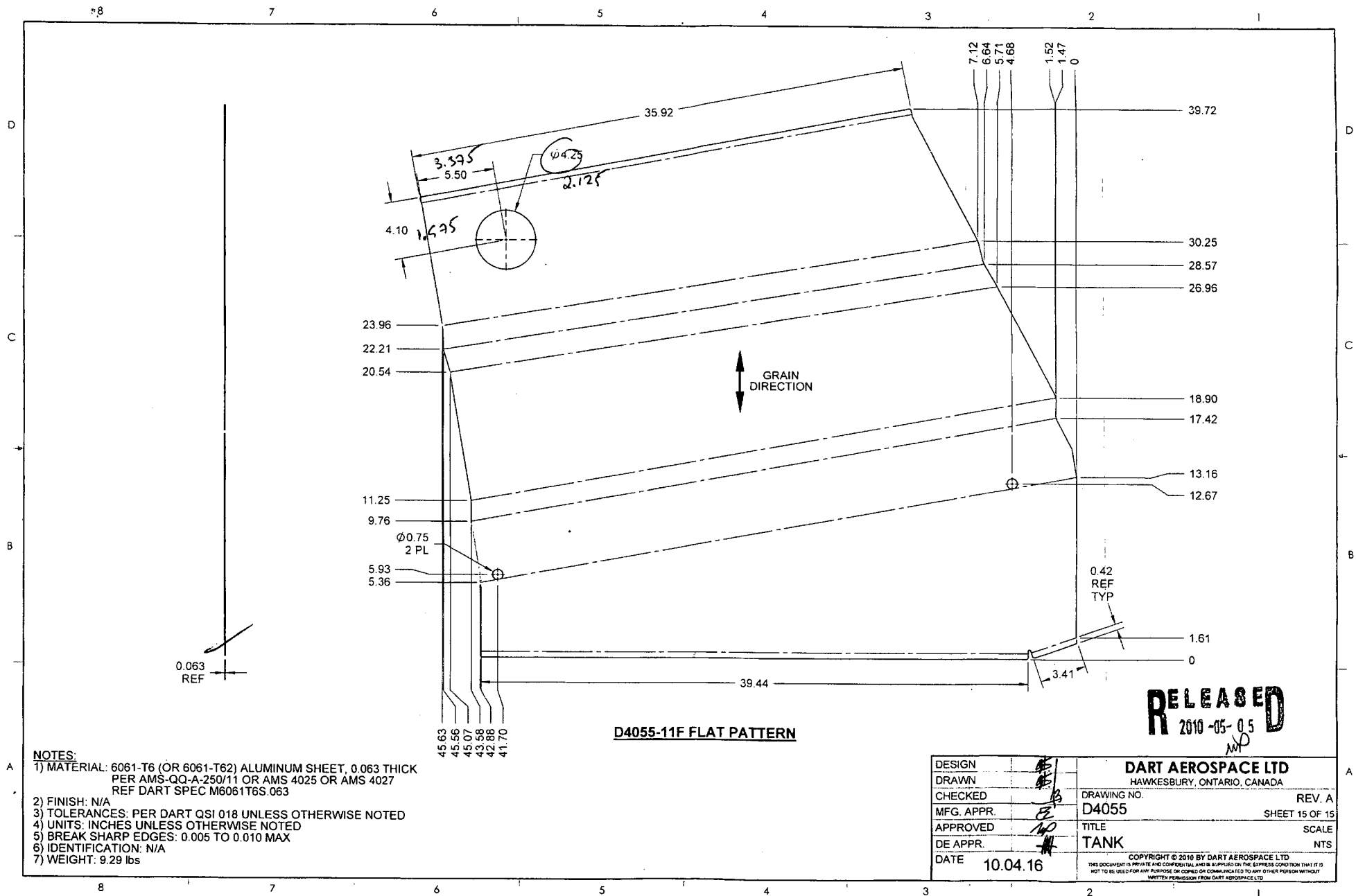
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
2010-05-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries